

Date: Tuesday, 2/26/2008 7:59:54 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	STRUT
Job Number	37606		
Estimate Number	10984		
P.O. Number		Part Number	D2565403
This Issue	2/26/2008	S.O. No.	D2565 REV E
Prsht Rev.	NC	Project Number	N/A
First Issue	/ /	Drawing Revision	E
Previous Run	25391	Material	
Written By		Due Date	3/25/2008
Checked & Approved By	<i>JF 08/03/06</i>	Qty:	6 Um: Each
Comment	Est:A 04.05.10 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W
	Comment: Qty.: 1.4560 f(s)/Unit Total : 8.7362 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049)	Batch No: <i>M107 099</i> <i>SB 08/03/04</i> (6)
2.0	BRAKE NC	NC BRAKE
	Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313	<i>SB 08/03/04</i> (6)
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		<i>SB 08/03/05</i> (6)
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill hole open to Ø0.316" as per Dwg D2565 (one end only) Deburr	
4.0	QC5	INSPECT WORK TO CURRENT STEP
		<i>SB 08/03/05</i> (6)
	Comment: INSPECT WORK TO CURRENT STEP	
5.0	POWDER COATING	POWDER COATING
		<i>M107005</i> <i>6X</i> <i>SB 08/03/06</i> (6)
	Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3	

Dart Aerospace Ltd

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/03/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STRUT

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Part Number: D2565403

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HJ



08-03-06

X 6

Comment: INSPECT POWDER COAT

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S7205

L83/6 (6)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Do 03/06

Job Completion



2008/3/06 (6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

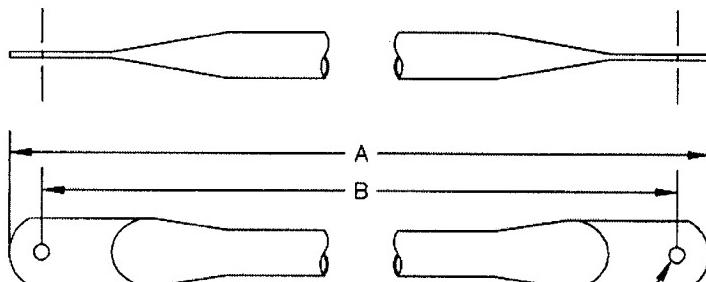
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. E	SHEET 1 OF 1
		D2565		
DATE		TITLE	SCALE	
04.05.05		STRUT		1:3
A	96.05.03	NEW ISSUE		
B	97.03.15	CORRECT D2565-111 DIM. A		
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)		
D	02.06.05	ADD -3XX PARTS; ADD FINISH		
E	04.05.05	ADD D2565-401-411; RMV ANGLE D		

RELEASED
04.05.05



DIA 0.257 TO BE PUNCHED
 "C" DIA TO BE OPENED MANUALLY
 PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.03	0.316

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 WITHOUT NOTICE
 WORK ORDER
 NO. 37606

GENERAL NOTES

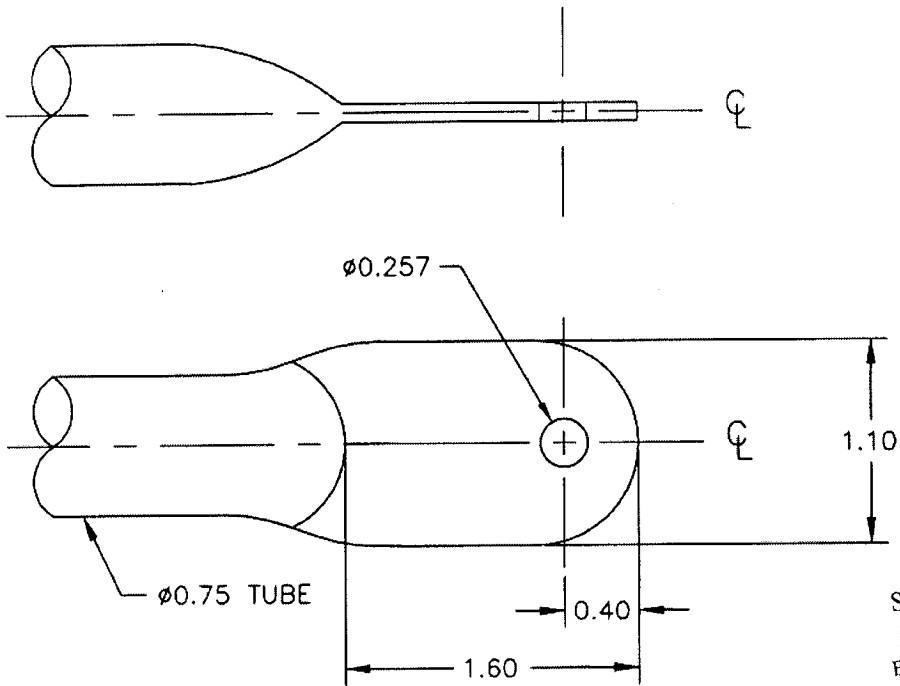
- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
 (REF. DART SPEC. M304TR0.750W0.049)
 ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

DART

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED M	APPROVED J	DRAWING NO. D2638
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL
		SCALE 1:1
A	98.04.28	NEW ISSUE

RELEASED
98/05/05 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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NO. 37606